

Date: Tuesday, 7/17/2007 2:00:37 PM
 User: Kim Johnston

Process Sheet

| | |
|---|--------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STRUT |
| Job Number : 33591 | |
| Estimate Number : 11043 | |
| P.O. Number : <i>N/A</i> | Part Number : D28103 |
| This Issue : 7/17/2007 S.O. No. : <i>N/A</i> | Drawing Number : D2810 / D2727 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>NA</i> | Drawing Revision : C / A1 |
| Previous Run : <i>N/A</i> | Material : <i>N/A</i> |
| Written By : _____ | Due Date : <i>7/31/2007</i> |
| Checked & Approved By : <i>07.07.14</i> | Qty: 12 Um: Each |
| Comment : Est. C 03.09.12 Reformat, Added powder coat KJ/RF | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0500W035 | 304 RD Tube .500 x .035W |
|-----|----------------|--------------------------|



Comment: Qty.: 2.2750 f(s)/Unit Total : 27.3004 f(s)

304 RD Tube .500 x .035W

Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control

Dwg D2727 using Jig DT8012

Batch: *11 104 8870**FF 07/08/14**12*

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012

2-Deburr

*FF 07/08/14**12**MF 07-08-20*

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

comp
Er 07/08/20 (4/2)

| | | |
|-----|----------------|----------------|
| 4.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FL 07/08/23 (12)

| | | |
|-----|-----|---|
| 5.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/8/23 SQ (RX)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/08/24
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:00:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 33591

Part Number: D28103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 7/08/23 (12)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

DA 7/08/24

Job Completion



U 7-08-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

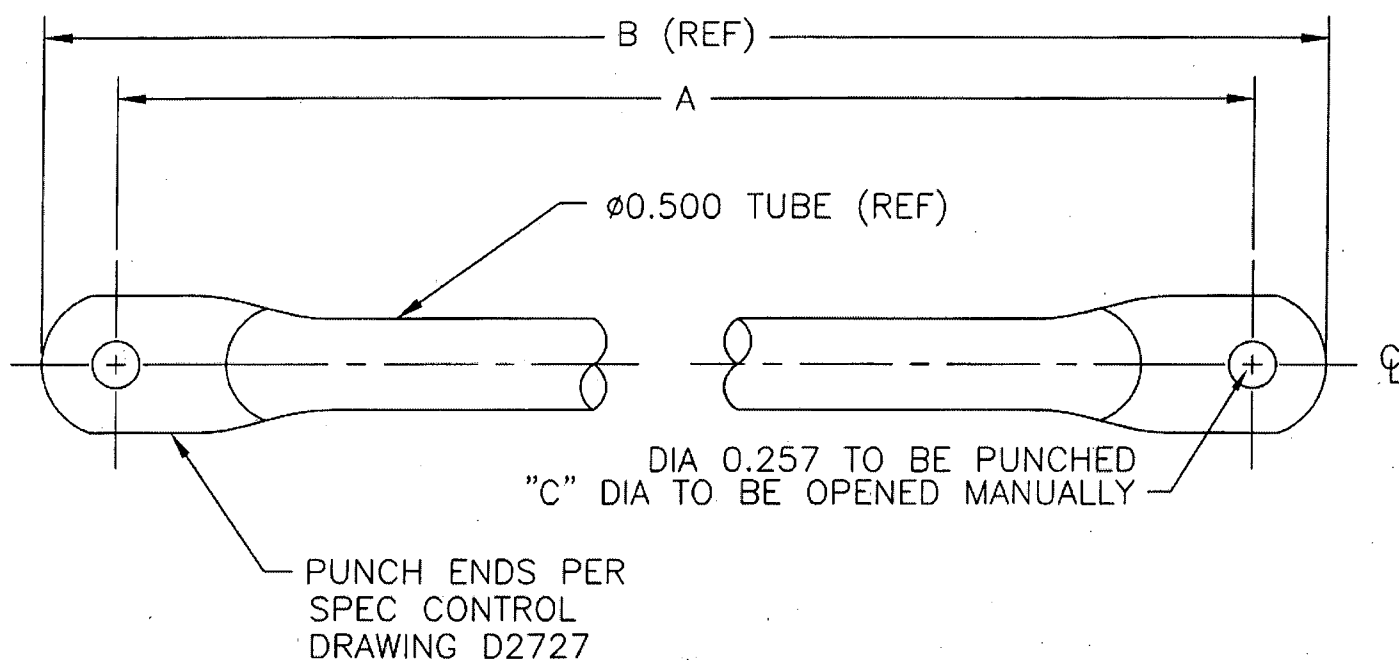
NOTE: Date & initial all entries



| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2810 | REV. C SHEET 1 OF 1 |
| DATE 04.11.22 | | TITLE STRUT | SCALE NTS |
| A | 00.11.08 | NEW ISSUE | |
| B | 03.09.11 | ADD FINISH | |
| C | 04.11.22 | ADD -5 | |

RELEASE

05.03.11



| PART # | A | B | C |
|---------|-------|-------|-------|
| D2810-1 | 25.33 | 26.13 | N/A |
| D2810-3 | 24.60 | 25.40 | N/A |
| D2810-5 | 23.01 | 23.81 | 0.266 |

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WITHOUT NOTICE
WORK ORDER
NO. 33591

D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.500 \times 0.035$ WALL (M304TRO.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

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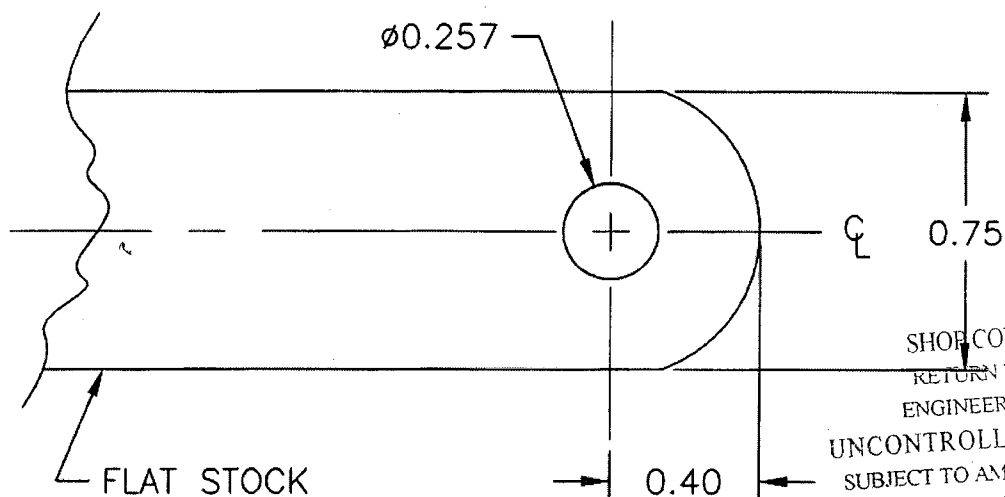
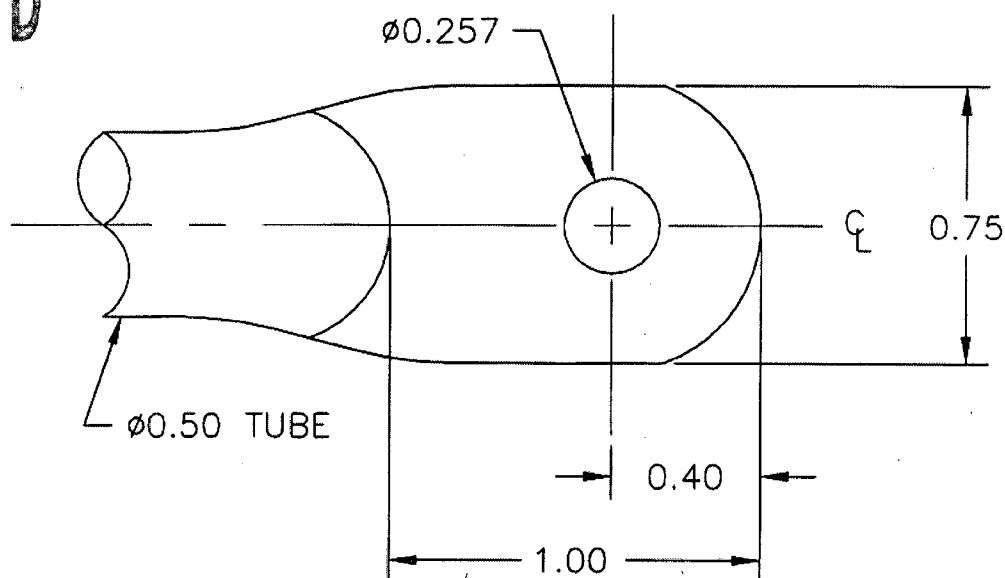
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| | | | |
|-----------------------|-------------------------|--|------------------------|
| DESIGN <i>KE</i> | DRAWN BY <i>KE</i> | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>MEY</i> | APPROVED <i>CA</i> | DRAWING NO. D2727 | REV. A SHEET 1 OF 1 |
| DATE 97.11.24 | | TITLE PUNCH DT8012 SPEC CONTROL | SCALE 2:1 |
| A | 97.11.24 | NEW ISSUE | |
| A1 | FCP 01.12.20 | ADD TOLERANCE NOTE | |

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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